

MARKED-UP COPY

Process for Manufacturing Side Fold Sacks made of Plastic Film

BACKGROUND OF THE INVENTION

1. FIELD OF THE INVENTION

The invention relates to a process for manufacturing side fold sacks from a flat lying segment of a web of plastic tubular film.

2. DESCRIPTION OF THE RELATED ART

Side fold sacks made of plastic, for example polyolefin films, like PE and PP, are manufactured from flat lying segments of a web of plastic tubular film by providing a weld, which runs at right angles and grasps all layers, on one end. Owing to the typically high weight of the fill material and the resulting load on the sacks, ~~said~~ such sacks are usually made of especially thick plastic films. On tubular segments made of plastic films of such thickness, the bottoms can be affixed only by means of transverse welds, whose execution requires a long welding time. The welding operation requires that the heat be passed through all of the layers of film, ~~thus which,~~ in the area of the side folds, requires heat passage through four layers of film, in order to guarantee the requisite melting and welding together. This thermal conductivity process time, which increases as the thickness of the film and the number of layers ~~increase~~ increases, results in a significantly

long welding period so that the sacks can be manufactured only at low efficiency.

SUMMARY OF THE INVENTION

Therefore, the object of the invention is to propose a process of the type described in the introductory part and according to which side fold sacks made of plastic film can be manufactured ~~at a higher rate~~ with greater efficiency.

The invention solves this problem in that one end of the segment of a web of plastic tubular film is provided in such a manner with a staggered cut or a staggered detachment along a perforation that, in a top view of the staggered portion, ~~stagger~~ the rear wall projects beyond the front wall. The upper surfaces of the staggered portion are ~~and that the stagger is~~ provided with an application of adhesive as far as into the area of a fold line, which is located ~~in the area of~~ adjacent the free bottom edge of the front wall, ~~that has been cut free,~~ and the staggered portion ~~stagger~~ is folded along the fold line and over the ~~fold~~ free edge to be affixed onto the front wall. Such a process for manufacturing side fold sacks made of paper already exists. The invention is based on the surprising knowledge of the benefit ~~and measure~~ of transferring this process ~~known in the manufacture of paper sacks~~ to the manufacture of plastic sacks, where the bottoms

were affixed hitherto by means of welds.

Plastic adhesives, for example polyurethane adhesive or hot melt, are used as the adhesive to cement the folded over ~~stagger~~ staggered portion to the front wall.

The cementing operation can be improved by further subdividing the ~~stagger~~ staggered portion. Expediently, when viewed from above, a portion of the rear wall projects, in a top view of the stagger, beyond the side folds, and a portion of, and the side folds project projects beyond the front wall.

The ~~stagger can also grasp~~ staggering of the layers may be further increased by forming the side folds in such a manner that the bottom layers of the side folds project beyond the upper layers.

A preferred embodiment provides that the perforation lines are formed in ~~affixed on~~ a flat lying web of plastic at intervals equal to the length of the segments of a web of plastic tubular film, before ~~said the~~ the segments are separated. The added to ~~a side fold tubular web is formed~~ by folding the web sides so as to overlap and simultaneously inserting side folds and affixing a center weld which runs lengthwise. Thus, starting from the part that forms the rear wall, the perforation lines ~~can~~ pass in steps over those parts that form the side folds into the part that forms the front wall, whereby the transverse segments of the perforation

~~line~~ lines are parallel to each other. One embodiment of the invention is explained in detail below with reference to the drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 is a perspective view of one end of a flat lying segment of a web of plastic tubular film, which is provided with side folds, ~~said~~ the end being provided with a staggered detachment.

Figure 2 is a top view of ~~a~~ the bottom of a plastic side fold sack, ~~the made of plastic,~~ said bottom being formed by cementing.

Figure 3 is a cross sectional view along line III - III of ~~the~~ sack, ~~according to Figure 2, in an exploded~~ drawing.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

Further scope of applicability of the present invention will become apparent from the detailed description given hereinafter. However, it should be understood that the detailed description and specific examples, while indicating preferred

embodiments of the invention, are given by way of illustration only, since various changes and modifications within the spirit and scope of the invention will become apparent to those skilled in the art from this detailed description.

Figure 1 depicts a segment 1 of a web of plastic tubular film, severed along a perforation line from a flat lying web of plastic tubular film, which is provided with side folds. ~~The web of plastic tubular film was~~ perforation lines are provided in such a manner with ~~a perforation line, provided with~~ graduations or steps, that the ~~result is a stagger~~ segment has a staggered end, which is evident from Figure 1.

The ~~stagger~~ staggering of the layers on the end of the segment of ~~a~~ the web of tubular film, ~~to which the bottom is affixed where the cemented bottom is to be formed~~, is designed in such a manner that in a top view of the segment 1, ~~of a web of tubular film~~ the rear wall 2 projects beyond the side folds 3, while the side folds project beyond the front wall 4, with the front wall being provided with a corresponding free ~~cut~~ edge 6. The perforation line, along which the segment ~~of a web of tubular film~~ is severed from the web of tubular film to form the ~~stagger~~ staggered end, is already ~~affixed in a~~ formed in the flat web of ~~tubular~~ film, from which then the web of tubular film is formed by folding the side parts so as to overlap and simultaneously

inserting the side folds and affixing a longitudinal center weld.

To manufacture side fold sacks, the upper surfaces of the staggered or stepped portions of the rear wall 2 and of the side folds 3 ~~layers 2, 3~~ are provided with a suitable application of adhesive. The staggered portions are, ~~and the stagger is~~ then folded over the fold line 5 and pressed against the front wall 4 so that the result is the cemented bottom, illustrated in Figure 2.

The position of the staggered portions of the rear wall 2, the side folds 3 and that part of the front wall 4 adjacent the free edge 6 ~~stagger~~s in the finished, cemented side fold sack is ~~evident from~~ shown in Figure 3. As shown, a portion of the front wall between the fold line and the free edge 6 may also be adhered back against the upper surface of the front wall.

Another embodiment provides that the upper layer 7 of the side folds is also provided with a staggered cut along the dashed lines 8 in Figure 1 so that the bottom layer of the side fold projects beyond the upper layer 7.

The invention being thus described, it will be apparent that the same may be varied in many ways. Such variations are not to be regarded as a departure from the spirit and scope of the invention, and all such modifications as would be recognized by one skilled in the art are intended to be included within the scope of the following claims.